

Date: Thursday, 3/20/2008 9:54:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2896-1
Job Number	: 38134		
Estimate Number	: 13237		
P.O. Number	:	Part Number	: DSK081
This Issue	: 3/20/2008 S.O. No. :	Drawing Number	: DSK081 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>JA 08 03 20</u>	Due Date	: 4/3/2008 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: est rev A. 08.03.13 new issue EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

Seq. # 1.0

D6104007

17-4 SS Roundbar 4.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: 3868920 08/05/31

⑩

Seq. # 2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA079

ACQ 08/06/01

Seq. # 3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ACQ 08/06/01

Seq. # 4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 08/06/02

⑩

Seq. # 5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC20 08/06/01

Seq. # 6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion

W 08/06/03

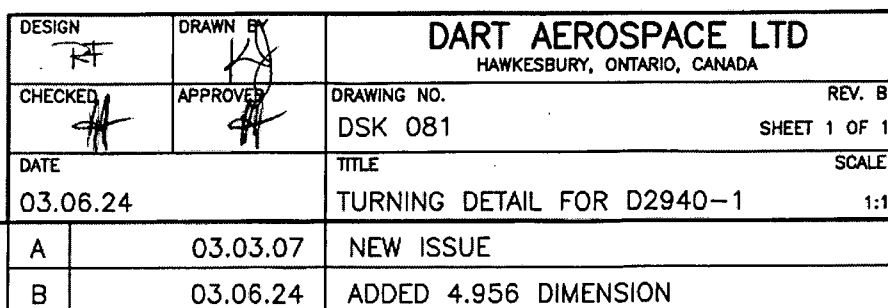
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

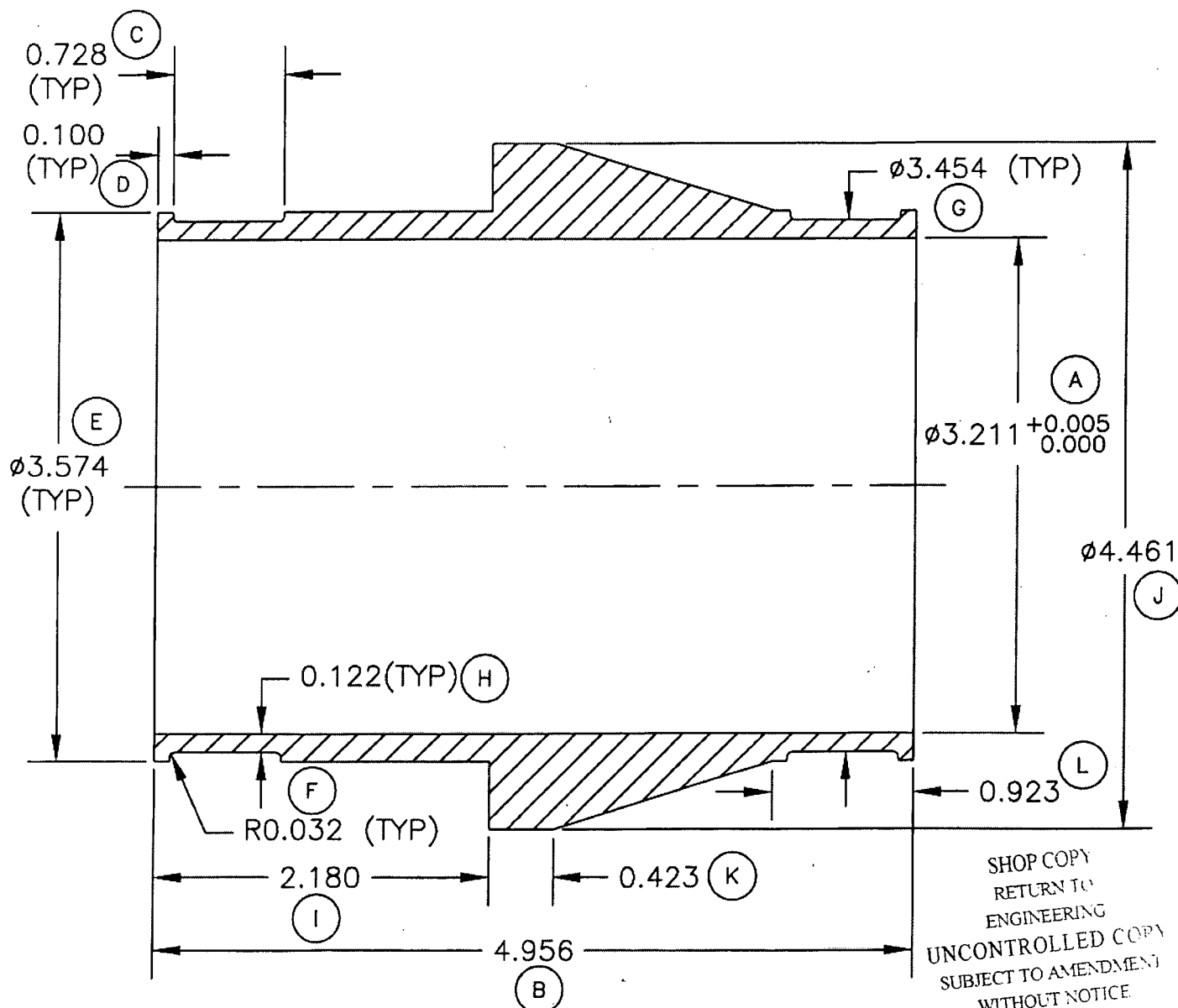
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
03-07-01



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38134

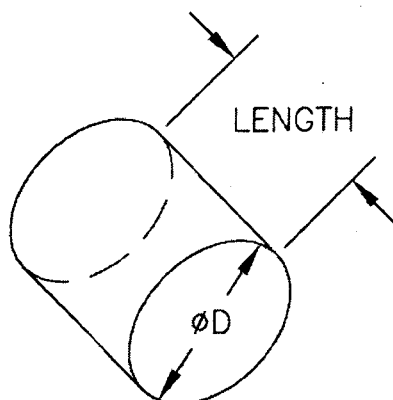


DESIGN <i>EF</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4 SCALE NTS	
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED

02.11.25

SPECIFICATION CONTROL DRAWING



W/b 38134

MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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DART AEROSPACE LTD		Work Order:	38134
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.725	.725	.725	.725	.725
D	0.090	0.110		.100	.102	.102	.102	.102
E	3.564	3.584		3.575	3.575	3.575	3.575	3.575
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.122	.122	.122	.122	.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: <i>TC</i>	Date: 08/06/01
Audited by: <i>LF</i>	Date: 08/06/02
Prototype Approval: <i>N/A</i>	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

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D	0.090	0.110		.102	.102	.102	.102	.102
E	3.564	3.584		3.575	3.575	3.575	3.575	3.575
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.122	.122	.122	.122	.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by:	RC	Date:	08/06/01
Audited by:	LF	Date:	08/06/02
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	JA